

Work Order ID 60344

Tuesday, July 06, 2010 9:54:26 AM



Page 1

Item ID: D2534

Accept



Setup Start



Revision ID:

Stop



Item Name: Lock Plate

Start Date: 7/6/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 7/9/2010 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: mf

Date: 10-7-6

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2534

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2734 ☐ Dwg Rev: D ☐ Prog Rev: D ☐ 2-
Deburr if necessary

Deburr = m-h 10/07/07

ml 10.07.06 (50)

(50X)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ml 10.07.06 (50)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/07/07

(count)
(x) 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: W/A20 0.00

Memo

0.00

PL 10.07.12

Packaging

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

JUL 13

PL 10-7-12
(50)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 06, 2010 9:54:25 AM

Page 1

Work Order ID: 60344



Parent Item: D2534



Parent Item Name: Lock Plate

Start Date: 7/6/2010

Required Date: 7/9/2010

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
IPP Rev:B Now on Waterjet 06-06-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			110	sf	125.0259	0.0427	2.247368			



304/316 0.125 Sheet



Location

Loc Qty

Loc Code

MAT

125.0259

114488

1.5259

114799

123.5

ml 10.07.06

W/O:		WORK ORDER CHANGES					
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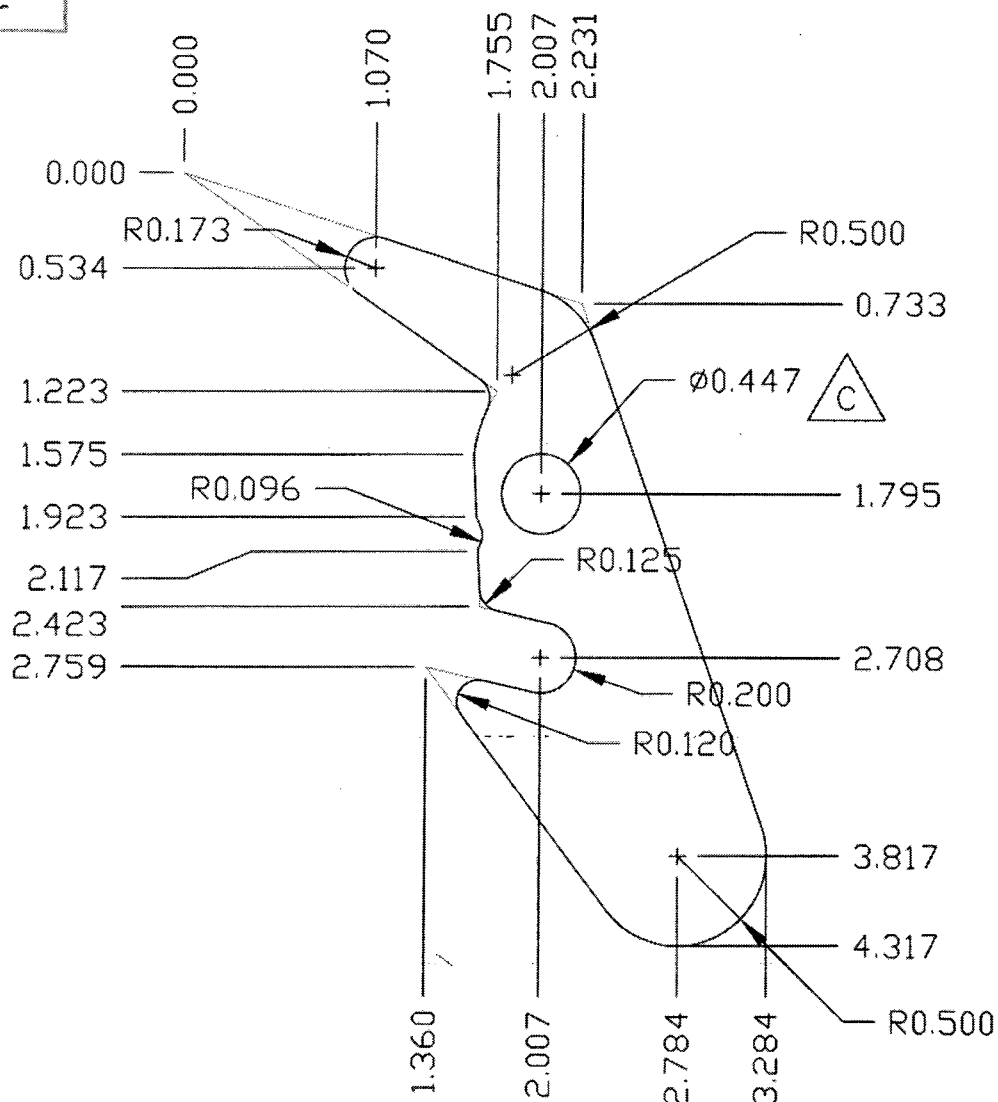
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO. D2534	REV. D SHEET 1 OF 1
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	TITLE LOCK PLATE	
DATE 04.12.14			SCALE 1:1
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

RELEASED

04.12.16 *[Signature]*

60344

**D2534 LOCK PLATE**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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